

Date: Tuesday, 12/20/2005 2:50:22 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STIFFENER	
Job Number	: 25295		Part Number	: D2353	
Estimate Number	: 10481		Drawing Number	: D2353 REV.B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 12/20/2005	S.O. No. : N/A	Drawing Revision	: B	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A	Type : MACHINED PARTS	Due Date	: 1/20/2006	
Previous Run	: N/A		Qty:	10	Um: Each
Written By	<u>SEE COMMENT BELOW</u>				
Checked & Approved By	<u>SEE ABOVE USER</u>				
Comment	: Est Rev: A Removed from 9 Digit 05-11-10 EC				

Additional Product

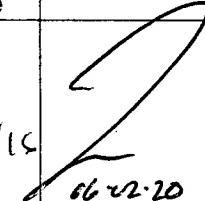
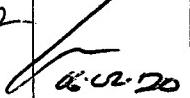
Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S050	2024-T3 .050 sheet	
		Comment: Qty.: 0.1536 sf(s)/Unit Total : 0.9217 sf(s) Material: 2024-T3 .050 sheet Aluminum (QQ-A-250/5) Batch: m15053	
2.0	SHEAR	SHEAR	
		Comment: SHEAR Cut blanks: 1.382" x 15.25"	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2353 7 dwg D2353	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/02/2023
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/02/16	6	I piece was bent out of tolerance and wasn't square small at one end, large at the other.		Scrap + destroy	SB 06/02/16 			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 2:50:22 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STIFFENER

Job Number: 25295

Part Number: D2353

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend per Dwg D2353

SB 06/02/16

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 06-02-21

9.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

FL 06 02 21

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M 06 02 22

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: St 121

PG/1/22 (9)

12.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/02/23

Job Completion



u 06-02-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25295
Description: Stiffener	Part Number:	D2353
Inspection Dwg: D2353	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

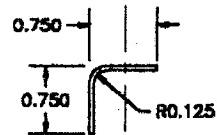
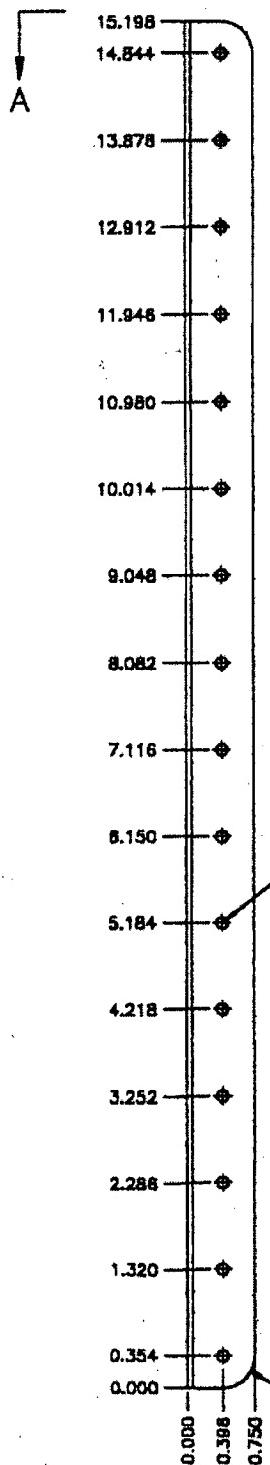
X First Article Prototype

Measured by:	J.L	Audited by:	E.S.	Prototype Approval:	N/A
Date:	06.02.06	Date:	06/02/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	

DART

DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>BW</i>	APPROVED <i>QA</i>	DRAWING NO. D2353
DATE 95:02:10	TITLE STIFFENER	REV. B SCALE 1:2
		SHEET 1 OF 1
B	95:02:23	ADD TEXT



SECTION A-A

SHOP COPY
REMANENT
ING IN

15

T

25295

MATERIAL 2024-T3 0.050 THICK
QQ-A-250/5
FINISH: POWDER COAT CRINKLE BLACK